

# Work Order ID 51339

August 19, 2009 11:34:47 AM



Page 1

|                |                        |            |      |       |       |  |
|----------------|------------------------|------------|------|-------|-------|--|
| Item ID:       | D3827-041              | Accept     |      | Setup | Start |  |
| Revision ID:   | A                      |            |      |       | Stop  |  |
| Item Name:     | Rib Assembly (Inboard) |            |      |       |       |  |
| Start Date:    | 08/19/2009             | Start Qty: | 6.00 |       |       |  |
| Required Date: | 08/25/2009             | Req'd Qty: | 6.00 |       |       |  |
| Reference:     |                        |            |      |       |       |  |

|            |               |           |       |                 |            |  |       |  |
|------------|---------------|-----------|-------|-----------------|------------|--|-------|--|
| Approvals: | Process Plan: | <u>mf</u> | Date: | <u>09.08.19</u> | Tooling:   |  | Date: |  |
|            | QC:           |           | Date: |                 | SPC (Y/N): |  | Date: |  |

|     |       |  |
|-----|-------|--|
| Run | Start |  |
|     | Stop  |  |

| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Draw<br>Number | Draw<br>Rev. | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
| <b>Draw Nbr</b>                | <b>Revision Nbr</b>      |                      |                |              |              |               |               |                  |                |
| D3827                          | Rev A                    |                      |                |              |              |               |               |                  |                |

|           |  |      |  |
|-----------|--|------|--|
| 100       |  | 0.00 |  |
|           | Large Fab  |      |  |
| Large Fab | Memo   | 0.00 |  |
| Large Fab | <p>1- cut D3827-1 rib as per dwg D3827□2- drill holes using DT9435 jig and open to finish size as per dwg D3827□3- c'sink as per dwg□4- remove identification markings□5- deburr</p> <p>SAD 09-08-20</p> |      |  |

⑥

|                 |   |      |  |
|-----------------|---|------|--|
| 110             | QC5- Inspect part completeness to step on W/O | 0.00 |  |
|                 |   |      |  |
| QC              | Memo  | 0.00 |  |
| Quality Control |   |      |  |

=> 8 09/08/20

⑥

|           |  |      |  |
|-----------|--|------|--|
| 120       |  | 0.00 |  |
|           | Large Fab  |      |  |
| Large Fab | Memo   | 0.00 |  |
| Large Fab | <p>1- weld bushing in rib as per dwg D3827 □ A/R ER316 S.S. Rod Batch: <u>M109213</u> □2- grind weld flush □3- deburr if necessary</p> <p>09.08.24</p> |      |  |

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

**Abstract**

August 19, 2009 11:34:47 AM

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**Setup Start**

**Stop**

|                       |            |                   |      |
|-----------------------|------------|-------------------|------|
| <b>Start Date:</b>    | 08/19/2009 | <b>Start Qty:</b> | 6.00 |
| <b>Required Date:</b> | 08/25/2009 | <b>Req'd Qty:</b> | 6.00 |

1. The first step in the process is to identify the problem or issue that needs to be addressed. This involves gathering information and understanding the context of the problem.

2. Once the problem is identified, the next step is to define the objectives and goals of the project. This helps to clarify what needs to be achieved and provides a clear direction for the team.

3. The third step is to develop a plan or strategy to address the problem. This involves breaking down the problem into smaller, manageable tasks and determining the resources needed to complete each task.

4. The fourth step is to implement the plan. This involves putting the strategy into action and monitoring progress to ensure that the project is on track.

5. The final step is to evaluate the results of the project. This involves assessing the outcomes against the objectives and goals and identifying any areas for improvement.

**Cust Item ID:**  
**Customer:**

**Reference:**

Run Start

**Approvals:**      **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_  
**QC:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **SPC (Y/N):** \_\_\_\_\_ **Date:** \_\_\_\_\_

**Stop**

### Operation Description

### Set Up/ Run Hours

**Draw  
Number**

**Draw  
Rev.**

**Plan  
Code**

| Accept | Qty |
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Reject  
QtyReject  
Number

**Insp.  
Stamp**

130

QC

## Quality Control

QC~~10~~ Inspect visual per QSI004- Fusion Welds

0.00

0.00

## Memo

140

QC

## Quality Control

QC5- Inspect part completeness to step on W/O

0.00

0.00

## Memo

150

### Packaging

## Packaging

Identify as per dwg & Stock Location: Basket

0.00

0.00

## Memo

JD 09.08.25

6

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |



**NOTE:** Date & initial all entries



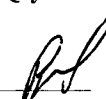
**Work Order ID 51339**

August 19, 2009 11:34:47 AM

Page 3

Item ID: D3827-041 Accept  Setup Start   
Revision ID: A Stop   
Item Name: Rib Assembly (Inboard)  
Start Date: 08/19/2009 Start Qty: 6.00  Cust Item ID:  
Required Date: 08/25/2009 Req'd Qty: 6.00  Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start   
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop 

| Sequence ID/<br>Work Center ID   | Operation<br>Description                                | Set Up/<br>Run Hours | Draw<br>Number | Draw<br>Rev.  | Plan<br>Code | Accept<br>Qty   | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--|---|----------------------|----------------|---|--------------|---|---------------|------------------|----------------|
| 160<br><br>QC<br>Quality Control | QC21- Final Inspection - Work Order Release<br><br>Memo | 0.00<br><br>0.00     | 09/08/26       |  |              |  | 09-8-25       |                  |                |

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Picklist Print

August 19, 2009 11:34:46 AM

Page 1

Work Order ID: 51339

Parent Item: D3827-041RevA

Parent Item Name: Rib Assembly (Inboard)

Comments:

Start Date: 08/19/2009

Required Date: 08/25/2009

Start Qty: 6.00

Required Qty: 6.00

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Remaining<br>Qty To Pick | Qty<br>Issued | Date<br>Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| D3759-1RevA                     |                        | Manufactured  | No          |                     |                  | 100             | Each               | 58.0000        | 18.0000                  |               |                |        |

Bushing

Warehouse Loc Qty Loc Code

Location

Main Warehouse

WA

58

50000

22

51136

36

M304TS0.750W.065

Purchased

No

100

f

1,352.362 50.5263



304 SQ Tube .75x.75x.065W

Warehouse Loc Qty Loc Code

Location

Main Warehouse

MAT

6.307103691

112051

-0.7368363

112263

7.04394

Main Warehouse

WA

1346.0554

112263

1.6735

112344

344.3819

112398

1000

CPL 09-08-24 (16) ✓  
CPL 09-08-24 (2) ✓

SAD 09-08-20

50.5263

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries



SHOP COPY  
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 51339  
MF 09-0819

D3827-041 RIB ASSY (INBOARD)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 4.59 lbs

| ITEM | QTY<br>-041 | P/N       | DESCRIPTION        |
|------|-------------|-----------|--------------------|
| 1    | X           | D3827-041 | RIB ASSY (INBOARD) |
| 2    | 3           | D3759-1   | BUSHING            |
| 3    | 1           | D3827-1   | RIB                |

RELEASED  
08/11/14

|            |             |    |          |
|------------|-------------|----|----------|
| A          | NEW ISSUE   | MB | 08.09.23 |
| REV.       | DESCRIPTION | BY | DATE     |
| DESIGN     |             |    |          |
| DRAWN      |             |    |          |
| CHECKED    |             |    |          |
| MFG. APPR. |             |    |          |
| APPROVED   |             |    |          |
| DE APPR.   |             |    |          |
| DATE       | 08.09.23    |    |          |

|  |              |
|--|--------------|
| DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA  |              |
| DRAWING NO.<br>D3827   | REV. A       |
| TITLE<br>RIB ASSY (INBOARD)  | SCALE<br>NTS |
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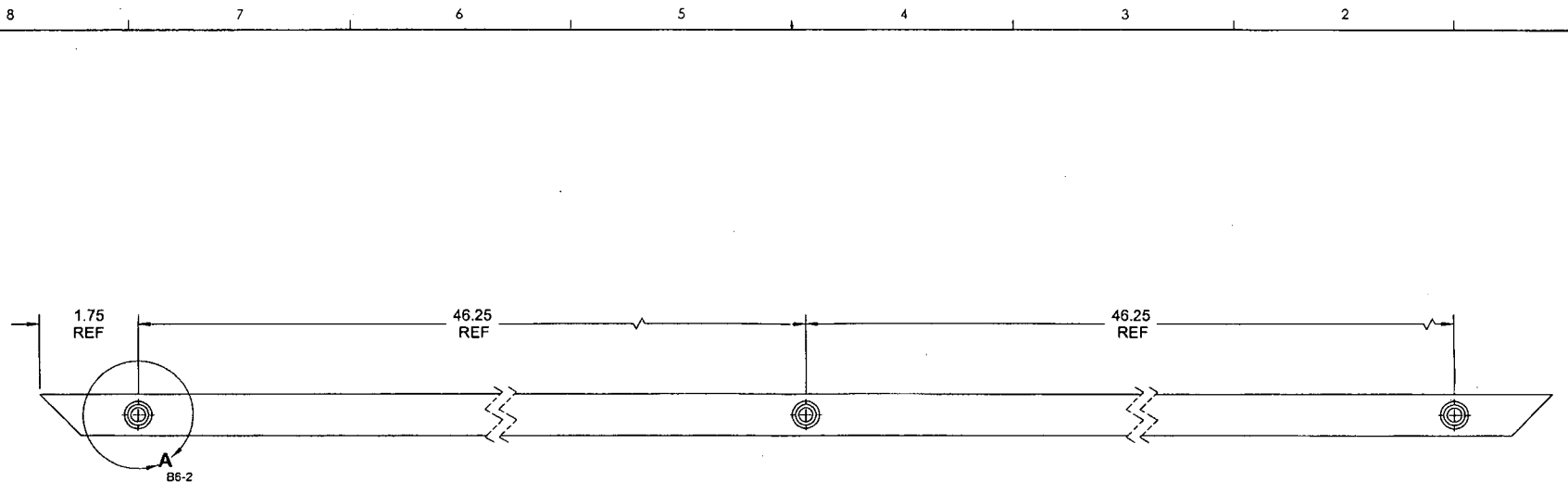
| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

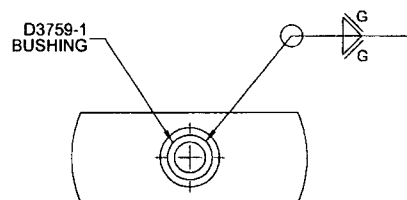
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries



**D3827-041 RIB ASSY (INBOARD)**



**DETAIL A**  
SCALE 2X  
3 PL

51339

**RELEASED**  
08/11/18 N/A

|            |          |   |              |
|------------|----------|---|--------------|
| DESIGN     |          | <b>DART AEROSPACE LTD</b>   |              |
| DRAWN      |          | HAWKESBURY, ONTARIO, CANADA   |              |
| CHECKED    |          | DRAWING NO. <b>D3827</b>  | REV. A       |
| MFG. APPR. |          | TITLE   | SHEET 2 OF 3 |
| APPROVED   |          | <b>RIB ASSY (INBOARD)</b>   | SCALE        |
| DE APPR.   |          |   | NTS          |
| DATE       | 08.09.23 | <small>COPYRIGHT © 2008 BY DART AEROSPACE LTD<br/>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS<br/>NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT<br/>WRITTEN PERMISSION FROM DART AEROSPACE LTD</small> |              |

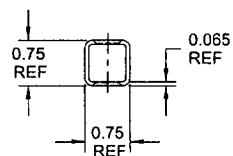
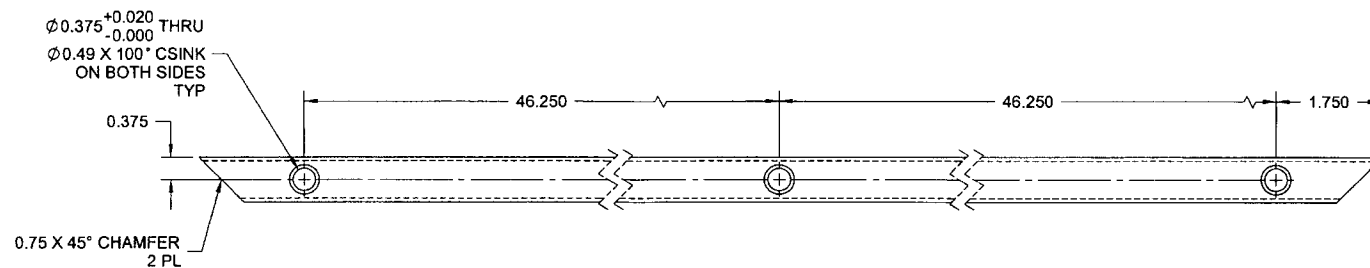
| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries



- NOTES:
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL  
REF. DART SPEC. M304TS0.750W0.065
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 4.55 lbs

|            |          |   |              |
|------------|----------|---|--------------|
| DESIGN     |          | <b>DART AEROSPACE LTD</b>   |              |
| DRAWN      |          | HAWKESBURY, ONTARIO, CANADA   |              |
| CHECKED    |          | DRAWING NO.   | REV. A       |
| MFG. APPR. |          | D3827   | SHEET 3 OF 3 |
| APPROVED   |          | TITLE   | SCALE        |
| DE APPR.   |          | RIB ASSY (INBOARD)  | NTS          |
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51339

RELEASED  
08/11/18

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries